

5/24

DART AEROSPACE LTD	Work Order:	23579
Description: Plug	Part Number:	D2651-1
11 03.12.19		
Drawing: D2651 Rev.A+B	Qty:	500

Step	Location	Procedure	By	Date	Qty
1	EXPEDITING	Open W/O	<i>[Signature]</i>	05.06.16	500
2	CNC CELL	Machine as per folio FA219 Material: 6061-T6(QQ-A-225/8) or equivalent. .500" Dia Batch <i>116491</i> <i>113466</i>	J.G	05/06/16	500
3	QC	Inspect level 2	J.G	05/06/20	500
4	QC	Inspect level 8	<i>[Signature]</i>	05.06.22	500
5	METAL	Deburr <i>and tumbler</i>	<i>ml</i>	05-06-27	495 PTO
6	QC	Inspect Level 5	<i>[Signature]</i>	05-07-04	454 PTO
7	FINISHING	Acid etch and alodine per QSI 005 4.1	<i>ML</i>	05 07 04	495
8	FINISHING	Powder coat gloss white (Ref: 4.3.5.1) per QSI 005 4.3 (Only larger section necessary)	<i>FL</i>	05 08 02	495
9	STORES	Identify and Stock	<i>FL</i>	05 08 02	495
10	EXPEDITING	Close W/O Inspect level 21 Cost / Part .70 <i>545 05/08/16</i> (495)	<i>[Signature]</i>	05/08/16	485

Rev	Date	Change	Revised By	Approved
A	02.04.15	New Issue	NG	<i>[Signature]</i> 02-04-15

RELEASED

02/04/15 *[Signature]*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR: 23579		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
05.06.20	2/3	Total length of plug is 0.009 over tol. (0.394"), are parts acceptable Qty 500	CP 05.06.20	Acceptable this time	[Signature] 05.06.21	[Signature] 05.06.20	CP 05.06.21 per QSI 042	[Signature] 05.06.20
05-06-27	5	Find the box done. We have to re-do the step 5	[Signature] 05-06-27	No Body sign the step. I re-do because there No Good and I sign	[Signature] 05-06-27	[Signature] 05-06-27	[Signature] 05-06-27	[Signature] 05-06-27
05-07-04	6	1 Plug found too short by 0.045 [Sketch]	[Signature] 05-07-04	Scrap	[Signature] 05-07-04	[Signature] 05-07-04	[Signature] 05-07-04	[Signature] 05-07-04

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 05/08/02

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

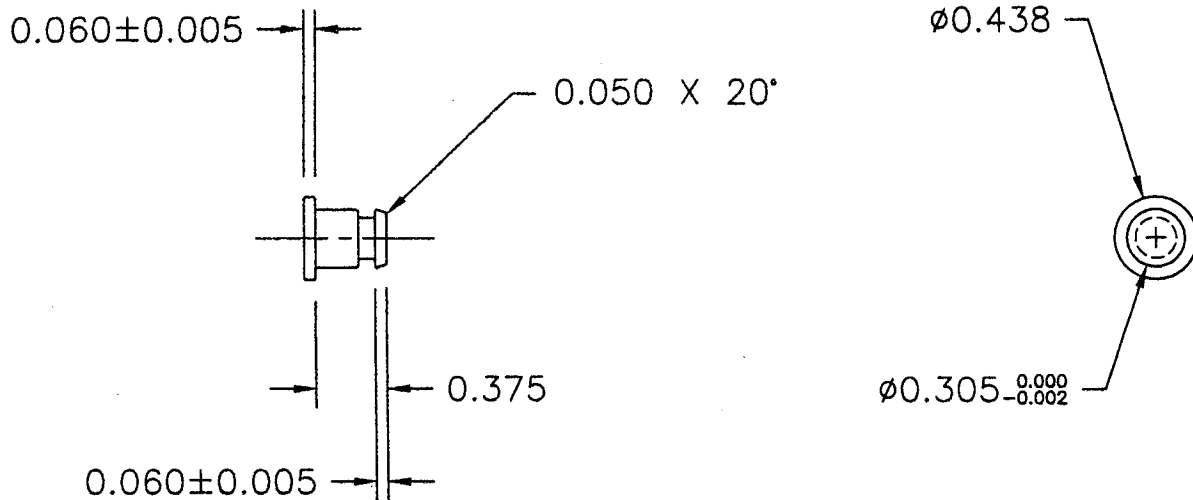


DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2651	REV. B SHEET 1 OF 1
DATE 03.12.19		TITLE PLUG	SCALE 1:1
A	97.03.25	NEW ISSUE	
B	03.12.19	ADD POWDER COAT, MS28775-008	

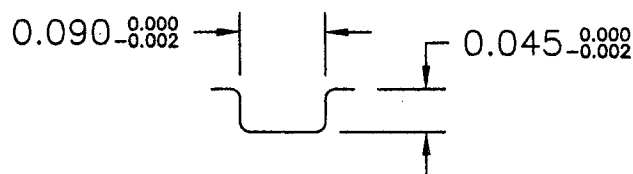
RELEASED

03.12.19 *[Signature]*

D2651-1 PLUG:



GROOVE DETAIL (SCALE 5:1)



D2651-1 PLUG

- 1) MATERIAL: 6061-T6 (QQ-A-225/8) OR 1100-0 (QQ-A-225/1)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.010 MAX

D2651-3 O-RING

- 1) MATERIAL: BUNA N, 70 DUROMETER
3/16 ID, 5/16 OD, 1/16 WIDTH
(PARKER 2-008, MS28775-008 OR EQUIVALENT)

SMOOTH COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER
NO. 23579

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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Jun 16, 2005
08:04 am

Work Order No : 0023579
Project Name : D2651-1
Project For : WK524
Work Order Type : Main
Main WO Number :
House Part Number : D2651-1
Description : Plug
Manufactured : Yes
Amount Req'd : 500
Amount Done : 0
Start Date : 06-15-05
Est Finish Date : 06-24-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Mark Up : 0.000%
Actual Mark Up : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00

Chris Provencal

From: "David Shepherd" <davids@dartaero.com>
To: "Chris Provencal" <chrisp@dartaero.com>
Sent: June 21, 2005 12:24 PM
Subject: Re: D2651-1 plug problem

0.394 is acceptable

----- Original Message -----

From: Chris Provencal
To: David Shepherd
Sent: Monday, June 20, 2005 1:08 PM
Subject: D2651-1 plug problem

D2651-1 plug (ie the o-ring plug for the 206 skidtubes), The parts are over tolerance by 0.009" (0.394") on the 0.375" dimension. Dan indicated that from his experience this shouldn't be a problem. I will send a fax of the dwg.

Sincerely,

Chris Provencal

***DART* Aerospace Ltd.**

Email...chrisp@dartaero.com

Phone...613-632-3336

Fax.....613-632-4443

21/06/2005